

Date: Tuesday, 17/02/2009 3:46:24 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE
Job Number : 45843	
Estimate Number : 12705	
P.O. Number :	Part Number : D35723
This Issue : 17/02/2009 S.O. No. :	Drawing Number : D3572 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 44818	Material :
Written By :	Due Date : 24/02/2009 Qty: 30 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-02-07 JLM est rev B rev.B dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .750 X 1.50
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(31)

Comment: Qty.: 0.0431 f(s)/Unit Total: 1.2915 f(s)

6061-T6 Bar .750" X 1.500"

Batch: M108118

not in computer

J.L 09/02/18

2.0	BAND SAW	BAND SAW
-----	----------	----------



(31)

Comment: BAND SAW

Cut blank .500" long

J.L 09/02/18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(31)

Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA685 Rev: C & Dwg D3572 Rev: C

2-Deburr per dwg D3572

H.A 09/02/20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(31)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/02/20

5.0	QC8	SECOND CHECK
-----	-----	--------------



(31)

Comment: SECOND CHECK

SP 09/02/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 3:46:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 45843

Part Number: D35723

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl

JS 09/02/23 (3)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24 JS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

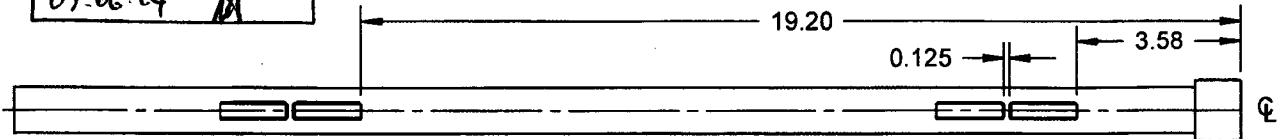
NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>#</i>	DRAWING NO. D3572	REV. C SHEET 1 OF 2
DATE 07.06.01	TITLE GUIDE ASSEMBLY		SCALE 1:4
REV	DATE	DESCRIPTION	
A	07.03.29	NEW ISSUE	
B	07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	
C	07.06.01	REMOVE D3572-7	

RELEASED

07-06-01 *#*



D3572-3 GUIDE
(4 PLACES)

3/16

4X

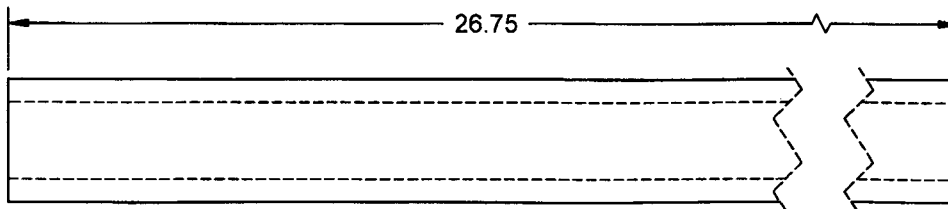
D3572-1 TUBE

D3572-041 GUIDE ASSEMBLY

D3572-5 BRACKET

D3572-041 NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004



D3572-1 TUBE

0.188 (REF) ϕ 1.000 (REF)

D3572-1 NOTES:

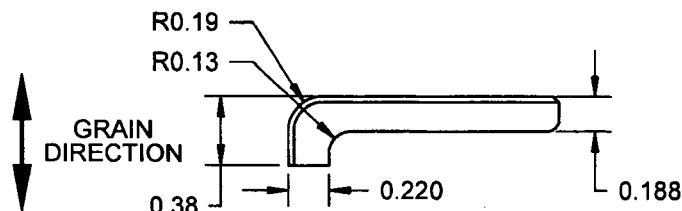
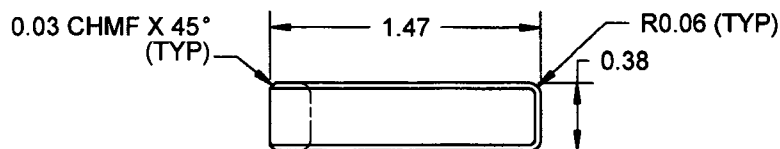
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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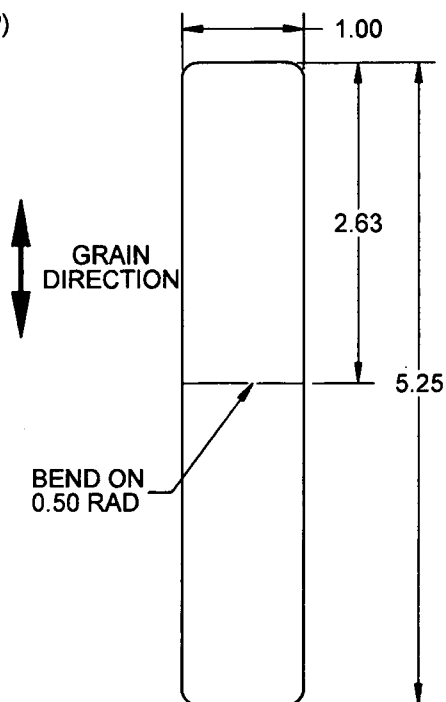
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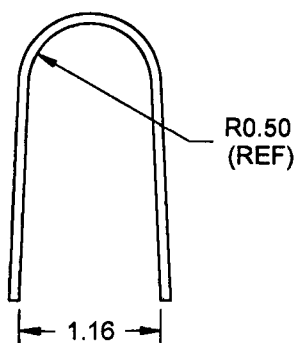
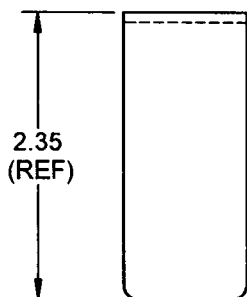
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 2 OF 2
DATE 07.06.01		TITLE GUIDE ASSEMBLY	SCALE 2:3



1 **D3572-3 GUIDE**



2 **D3572-5F FLAT PATTERN**



D3572-5 BRACKET
(MAKE FROM D3572-5F)

RELEASED

07.06.01 *H*

D3572-3/-5 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11
OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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